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D4640-15
Job Sheet 195187



Part No: D4640-15

Job Qty: 1 pcs

Part Name: Ceiling Protector



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/15/19

Job Tracking No:

Due Date: 5/20/19

Created By: Marie Lajeunesse

Type: SOLD

Description:

Note: DWG REV D SHEETS 8,9 IPP REV:A 12.05.08 NEW ISSUE DD VERF:EC IPP REV:B 12.10.17 AS PER REV.B VERF:JLM

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	1 pcs	5/20/19	5/20/19	0.00	0.28	Waterjet - Flow		05/19/27
110	QC 2	1 pcs	5/20/19	5/20/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		05/19/27
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		

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120 QC 8	1 pcs	5/20/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
130 Packaging 3-1 - Stock - B4B	1 pcs	5/20/19	0.00 0.00	Packaging 3 - 1 - B4B	
				Packaging 3 - 2 - B4B	
				Packaging 3 - 3 - B4B	
				Packaging 3 - 4 - B4B	
				Packaging 3 - 5 - B4B	
				Packaging 3 - 6 - B4B	
				Packaging 3 - 7 - B4B	
				Packaging 3 - 8 - B4B	
				Packaging 3 - 9 - B4B	
				Packaging 3 - 10 - B4B	
				Packaging 3 - 11 - B4B	
				Packaging 3 - 12 - B4B	
				Packaging 3 - 13 - B4B	
				Packaging 3 - 14 - B4B	
				Packaging 3 - 15 - B4B	
				Packaging 3 - 16 - B4B	
				Packaging 3 - 17 - B4B	
				Packaging 3 - 18 - B4B	
				Packaging 3 - 19 - B4B	
				Packaging 3 - 20 - B4B	
				Packaging 3 - 21 - B4B	
				Packaging 3 - 22 - B4B	
				Packaging 3 - 23 - B4B	
				Packaging 3 - 24 - B4B	
				Packaging 3 - 25 - B4B	
				Packaging 3 - 26 - B4B	
				Packaging 3 - 27 - B4B	
				Packaging 3 - 28 - B4B	
				Packaging 3 - 29 - B4B	
				Packaging 3 - 30 - B4B	
				Packaging 3 - 31 - B4B	
				Packaging 3 - 32 - B4B	

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MAY 28 2019

				Packaging 3 - 33 - B4B	
				Packaging 3 - 34 - B4B	
				Packaging 3 - 35 - B4B	
				Packaging 3 - 36 - B4B	
140 QC 21 - SA	1 pcs	5/20/19	0.00 0.00	QC 21 - SA - 21	
				QC 21 - SA - 70	MAY 28 2019 DAS
				QC 21 - SA - 53	70
Part Op 110 - QC2- Inspect parts off machine FAI/FAIB Descriptions: 120 - QC8- Inspect parts - second check 130 - Identify as per dwg & Stock Location: _____ 140 - Receive & Inspect for Damage & Mat'l Certs					
Job BOM					
Part / Item	Component Name	Quantity	Operation	Container	
MLEXS.093-F6006-07	GE Plastics Lexan Sheet (Light Grey)	16 sf (16 ea)	100-Waterjet - Flow - 1	8054824	
Job Allocations					
Operation	Component Part	Required	Inventory	Allocated	
100-Waterjet - Flow - 1	MLEXS.093-F6006-07	16	1,227	0	
Part Specifications					
Specifications could not be found.					

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DART AEROSPACE LTD		Work Order:	195187
Description: Ceiling Protector		Part Number:	D4640-15
Inspection Dwg: D4640	Rev: D	Page 1 of 1	

FIRST ARTICLE INSPECTION CHECKLIST

Drawing Dimension	Tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
18.80	+/-0.030	18.75	/		VDC-02	
22.03	+/-0.030	22.00	/		Tape	
20.06	+/-0.030	20.05	/			
13.06	+/-0.030	13.06	/			
3.60	+/-0.030	3.65	/			
8.09	+/-0.030	8.07	/			
20.86	+/-0.030	20.80	/			
3.11	+/-0.030	3.11	/			
7.27	+/-0.030	7.27	/			
5.10	+/-0.030	5.05	/			
4.85	+/-0.030	4.89	/			
13.06	+/-0.030	13.00	/			
1.50	+/-0.030	1.50	/			
5.00	+/-0.030	5.00	/			
57.46	+/-0.030	57.45	/			
82.37	+/-0.030	82.37	/			
Ø8.13	+0.012/-0.001	8.125	-			
6.77	+/-0.030	6.75	/			
5.72	+/-0.030	5.70	/			
6.13	+/-0.030	6.13	-			
2.21	+/-0.030	2.15	-			
0.88	+/-0.030	0.88	-			
7.78	+/-0.030	7.78	-			
7.47	+/-0.030	7.49	-			
Ø0.375	+0.006/-0.001	0.376	-			
9.73	+/-0.030	9.73	-			
21.00	+/-0.030	21.00	-			
31.28	+/-0.030	31.20	-			
4.00	+/-0.030	4.00	-			
27.23	+/-0.030	27.23	-			
22.28	+/-0.030	22.29	-			
20.36	+/-0.030	20.30	-			
0.093	+/-0.010	0.096	DAS			

Measured by: JRB	Audited by: 40 9-89	Preliminary Approval:
Date: 05/27/19	Date: MAY 28 2019	Date:

Rev	Date	Change	Revised by	Approved
A	12.09.26	New Issue	KJ	
B	13.02.27	Dwg Rev updated	KJ	

Entered: _____ Date: _____



WORK ORDER NON-CONFORMANCE / ROUTE UPDATE

NCR No. _____

Route update only ☐

Job: _____ Part No. _____	DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐	DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Eng. (Non-AW) ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Engineering ☐ Water Jet ☐ Supplier ☐ Quality ☐			
Date : _____	Sequence #: _____	QTY Affected : _____		MRB (QSI042)	
Description Work Order Deviation		Disposition		Completed By	
Root Cause Operator ☐ Manufacturing Process ☐ Equip/Tooling ☐ Handling/Presservation ☐ Material ☐ Product Improvement ☐ Process Improvement ☐ Human Factors ☐ ☐ Pressure/Forced ☐ Bending ☐ Crushing ☐ Cracks ☐ Crimp/Kink/Ripple/Wave/Twist ☐ Marks/Chatter ☐ Mislabeled		FAULT CATEGORY ☐ Contamination ☐ Misaligned/off center ☐ BOM/Route ☐ Broken/Damage/Defect ☐ Incomplete/Unclear Instructions ☐ Drill Holes ☐ Fit/Function ☐ Power Loss/Surge ☐ Folio/Program ☐ Grain Direction ☐ Weld ☐ Wrong Stock Pulled ☐ Out of Sequence ☐ Off-set/Set-up ☐ Positioned Wrong ☐ Outside Tolerance ☐ Drawing ☐ Finish ☐ Part Lost/Missing ☐ Misread			
Other/Details:					



Container No: S184152



Part: D4640-15

Job No: 195187

Serial No/Batch: S184152

Revision:

Inspector:

Exp Date:

Instructions: Various STC's

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